

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 165220

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165220

Page 2

Item ID: D3529-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 8/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/28/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							68-6 EE DAS
140									
QC	Memo	0.08							17/09/03
Quality Control									
150	Identify as per dwg & Stock Location: <u>374 SZH</u>	0.00							
150									
Packaging	Memo	0.04							SEP 05 2017 9-89 DAS 6
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40							17/9/16 JH
Quality Control									

DAS
21
9-89

SEP 05 2017

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 165220

165220

Parent Item: D3529-1

D3529-1

Parent Item Name: Bearpaw

Start Date: 8/21/2017

Required Date: 8/28/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-28 JLM
IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		100	sf	773.3310	1.5	6.31579			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

2017/08/18

Location

Loc Qty

Loc Code

MAT018

773.331

m136453

200

m137443

173.331

m138127

400

7

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OTHER : ☐					

DART AEROSPACE LTD		Work Order: 165220
Description: Bearpaw		Part Number: D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.50	+/-0.030	5.503	/		vern	mm L-05
B 0.07 x 45°	+/-0.030 x 0.5°	0.065 x 45°	/		"	
C R0.25	+/-0.030	0.250	/		RG	
D 0.250	+/-0.010	0.253	/		micro	mm L-01
E 0.625	+/-0.010	0.630	/		vern	mm L-05
F 0.950	+/-0.010	0.958	/			
G 1.63	+/-0.030	1.620	/			
H 12.14	+/-0.030	12.140	/		tape	
I						
J 5.70	+/-0.030	5.706	/		vern	mm L-05
K 0.375	+/-0.010	0.385	/		dept mic	118-120
L 0.525	+/-0.010	0.534	/		"	
M 0.13 x 45°	+/-0.030 x 0.5°	0.13 x 45°	/		vern	mm L-05
N R0.50	+/-0.030	0.500	/		RG	
O 12.76	+/-0.030	12.76	/		tape	
P 3.38	+/-0.030	3.375	/		vern	mm L-05
Q 3.75	+/-0.030	3.754	/			
R 5.187	+/-0.010	5.194	/			
S 5.25	+/-0.030	5.250	/			
T 7.13	+/-0.030	7.13	/			
U Ø0.260	+0.006/-0.001	0.260	/			
V 0.30	+/-0.030	0.305	/			
W 0.93	+/-0.030	0.928	/			
X 1.30	+/-0.030	1.304	/			

Measured by: DAS 49 9-89	Audited by: DAS 33 9-89	Prototype Approval: N/A
Date: 17/09/01	Date: 17/09/03	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

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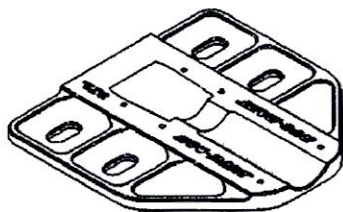


WORK ORDER NON-CONFORMANCE / UPDATE

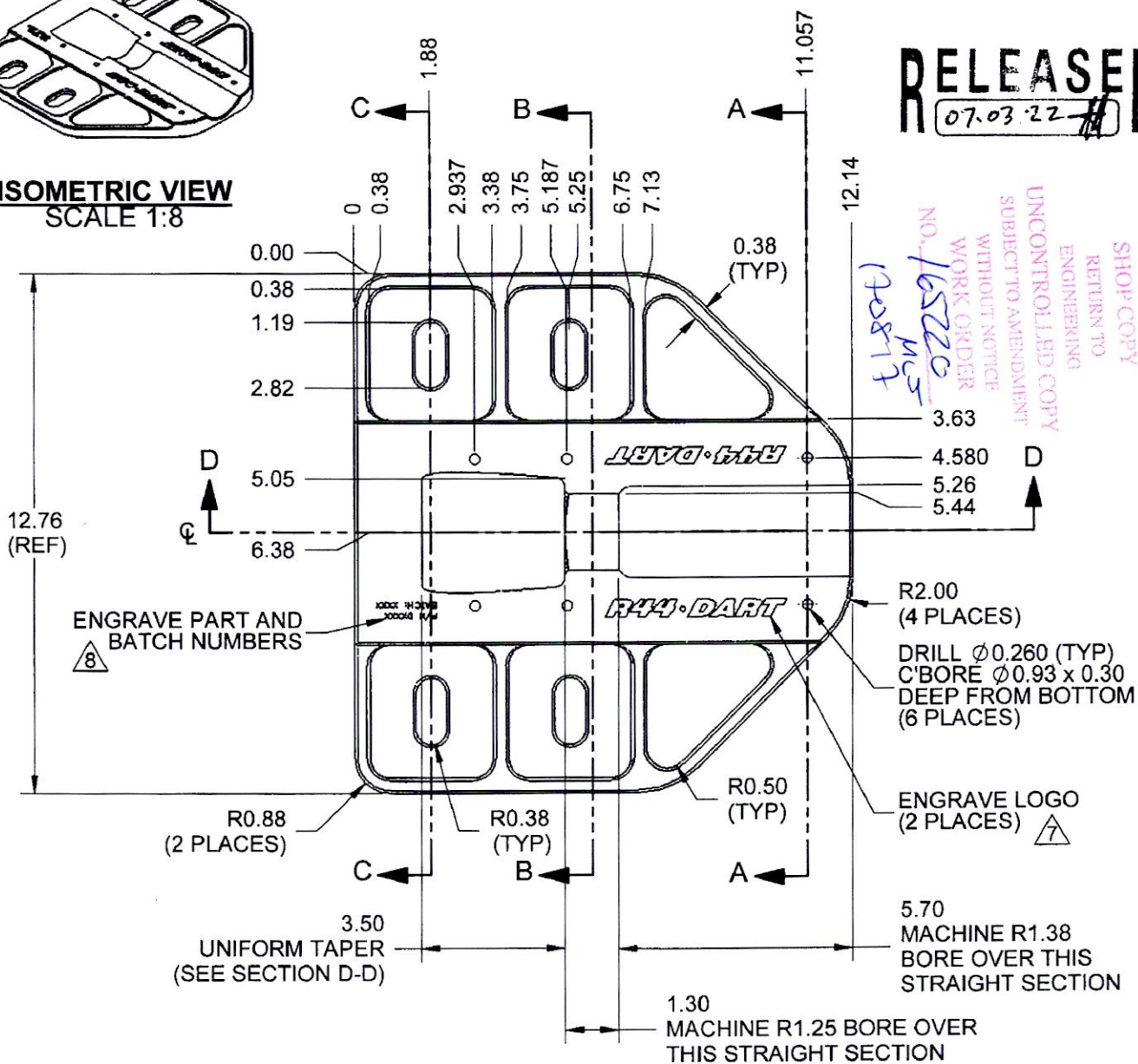
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OTHER : _____					



ISOMETRIC VIEW
SCALE 1:8



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
2) FINISH: NONE
3) PART IS SYMMETRIC ABOUT C
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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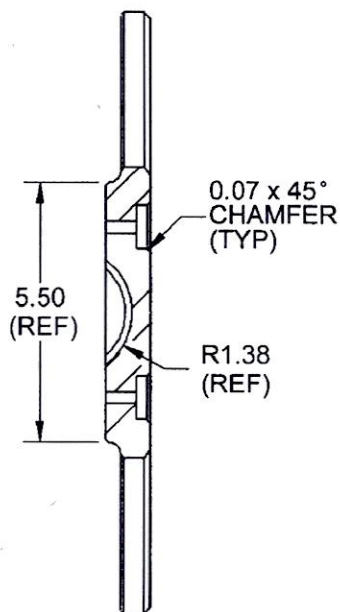
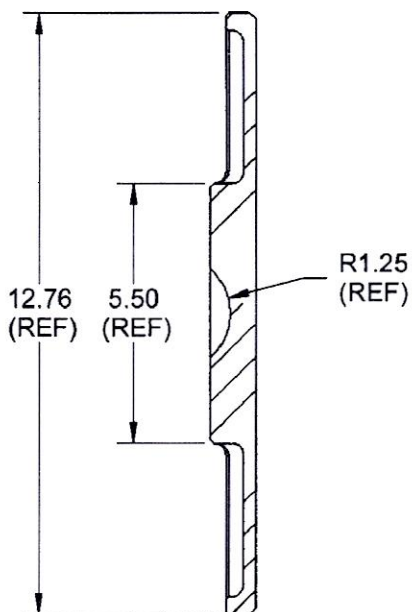
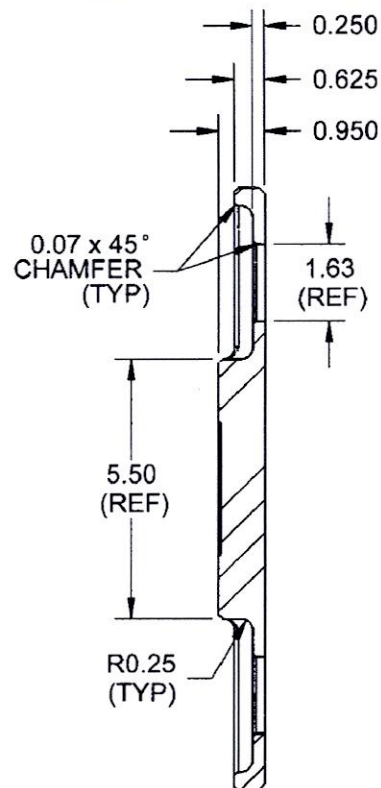
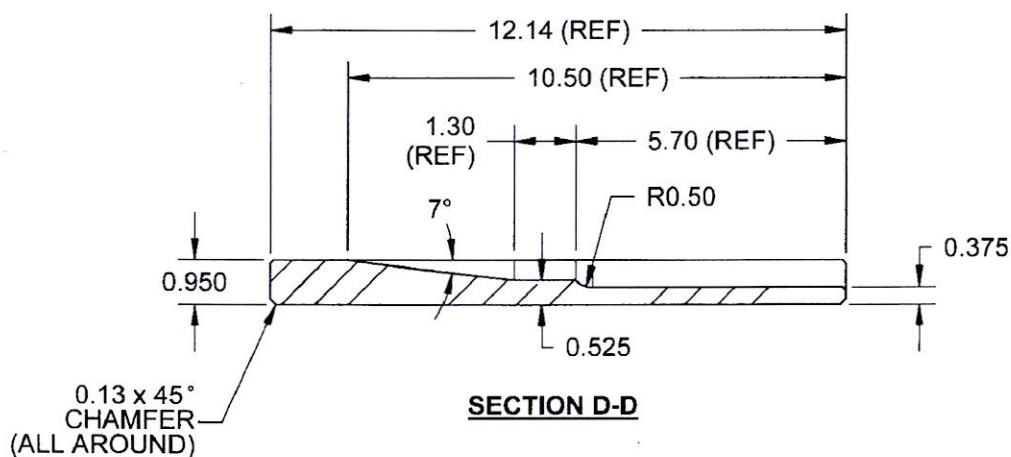
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OTHER : ☐									

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
07 03 22**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D****COPYRIGHT © 2007 BY DART AEROSPACE LTD**

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